Thursday, 1/17/2008 3:31:59 PM Date Kim Johnston User: **Process Sheet Drawing Name** : BUSHING : CU-DAR001 Dart Helicopters Services Customer Job Number : 36853 : 10173 **Estimate Number** : N)A : D2537 P.O. Number Part Number S.O. No. : 4)A · D2537 REV A1 **Drawing Number** This Issue : N/A Prsht Rev. Project Number Type : MACHINED PARTS First Issue : A1 **Drawing Revision** : 34788 MICHIE Previous Run Material Qty: : 1/30/2008 50 Um: Each Due Date Written By Checked & Approved By Comment : Est D 05.01.34 Material change on Step 2 KJ/JLM **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: 1.0 M304R500 0.500" 304 SS roundbar Comment: Qty.: 0.1203 f(s)/Unit Total: 6.0165 f(s) Material: AISI 304/316 Round Bar Ø0.500"(M304R.500) Batch: M105261 20 HARDINGE HARDINGE CNC LATHE SMALL Comment: HARDINGE CNC LATHE SMALL 1-Machine as per Folio FA273 3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 4.0 SECOND CHECK 08/01/27 Comment: SECOND CHECK PACKAGING 1 5.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 8/01/28 Location:

| <b>Dart Aerospa</b> | ce | Ltd |
|---------------------|----|-----|
|---------------------|----|-----|

| W/O: |      | WORK ORDER CHANGES |  |                     |  |      |     |                                     |                          |  |
|------|------|--------------------|--|---------------------|--|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | PROCEDURE CHANGE By |  | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |                     |  |      |     |                                     |                          |  |
|      |      |                    |  |                     |  |      |     |                                     |                          |  |
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|      |      |                    |  |                     |  |      |     |                                     |                          |  |
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|      |      |                    |  |                     |  |      |     |                                     |                          |  |

| Part No: _ | PAR #: | Fault Category: | NCR: Yes No DQA: | Date: <u>8/01/2</u> ° |
|------------|--------|-----------------|------------------|-----------------------|
|            |        |                 | QA: N/C Closed:  | Date:                 |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR)              |                      |                                 |                |           |                             |                          |              |          |          |
|------|------|---|----------------------|---------------------------------|----------------|-----------|-----------------------------|--------------------------|--------------|----------|----------|
|      |      | Description of NC Corrective Action Section B |                      | Corrective Action Section B     |                |           | Corrective Action Section B |                          | Verification | Amproval | Approval |
| DATE | STEP | Section A                                     | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign &<br>Date | Section C | Approval<br>Chief Eng       | Approval<br>QC Inspector |              |          |          |
|      |      |   |                      |                                 |                |           |                             |                          |              |          |          |
|      |      |   |                      |                                 |                |           |                             |                          |              |          |          |
|      |      |   |                      |                                 |                |           |                             |                          |              |          |          |
|      |      |   |                      |                                 |                |           |                             |                          |              |          |          |
|      |      |   |                      |                                 |                |           |                             |                          |              |          |          |
|      |      |   |                      |                                 |                |           | <u> </u>                    |                          |              |          |          |
|      |      | ,   |                      |                                 |                |           |                             |                          |              |          |          |
|      |      |   |                      |                                 |                |           |                             |                          |              |          |          |

NOTE: Date & initial all entries

Date:

Thursday, 1/17/2008 3:32:00 PM

Uŝer:

Kim Johnston

Customer: CU-DAR001 Dart Helicopters Services

**Process Sheet** 

Drawing Name: BUSHING

Part Number: D2537

Job Number: 36853

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



m 2008/1/28

Page 2

| Dart Aerospace Ltd | Da | art | Aer | 'os | pad | ce | Ltd |
|--------------------|----|-----|-----|-----|-----|----|-----|
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| W/O: *  |      | WORK ORDER CHANGES     |          |       |     |                                     |                          |  |
|---------|------|------------------------|----------|-------|-----|-------------------------------------|--------------------------|--|
| DATE    | STEP | P PROCEDURE CHANGE     |          | Date  | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|         |      |                        |          |       |     |                                     |                          |  |
|         |      |                        |          |       |     |                                     |                          |  |
|         |      |                        |          |       |     |                                     |                          |  |
| Part No | ,•   | PAR #: Fault Category: | NCR: Yes | No DO | Α.  | Date:                               |                          |  |

QA: N/C Closed: \_\_\_\_ Date: \_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                              |                |                           |                       |                         |  |
|------|------|----------------------------------|----------------------|------------------------------|----------------|---------------------------|-----------------------|-------------------------|--|
|      |      | STEP Description of NC           |                      | Corrective Action Section B  |                |                           |                       |                         |  |
| DATE | STEP | Section A                        | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspecto |  |
|      |      |                                  |                      |                              |                |                           |                       |                         |  |
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|      |      |                                  |                      |                              |                |                           |                       |                         |  |

NOTE: Date & initial all entries

| DART AEROSPACE LTD            | Work Order:  | 36853       |
|-------------------------------|--------------|-------------|
| Description: Bushing          | Part Number: | D2537       |
| Inspection Dwg: D2537 Rev: A1 |              | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing<br>Dimension | Tolerance     | Actual<br>Dimension     | Accept | Reject | Method of<br>Inspection | Comments |
|----------------------|---------------|-------------------------|--------|--------|-------------------------|----------|
| 1.250                | +/-0.010      | 1.249<br>0.318<br>Ø.438 |        |        |                         |          |
| 0.316                | +0.005/-0.000 | 0.318                   |        |        |                         |          |
| Ø0.438               | +/-0.010      | Ø.438                   |        |        |                         |          |
|                      |               |                         |        |        |                         |          |
|                      |               |                         |        |        |                         |          |
|                      | 1,74,         | <u> </u>                |        |        |                         |          |
|                      |               |                         |        |        |                         |          |
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|                      |               |                         |        |        |                         |          |

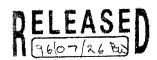
| Measured by: | H.A    | Inf | Audited by: | J.F.     | Prototype Approval: | N/A |
|--------------|--------|-----|-------------|----------|---------------------|-----|
| Date:        | 08/01/ | 24  | Date:       | 08/01/24 | Date:               | N/A |

| Rev | Date     | Change                      | Revised by | Approved |
|-----|----------|-----------------------------|------------|----------|
| Α   | 03.11.11 | New Issue                   | KJ/RF      |          |
| В   | 05.02.17 | Added Ø0.438                | KJ/JLM LA  |          |
| С   | 07.10.31 | Tolerance revised on Ø0.438 | KJ/EC/DD   | 177      |

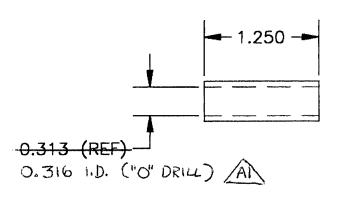




|   | DESIGN     | DRAWN BY   | DART        | AEROSPACE              | LTD    |        |
|---|------------|------------|-------------|------------------------|--------|--------|
| 1 | B WILLIAMS | B WILLIAMS | VICTORIA    | INTERNATIONAL AIRPORT, | CANADA |        |
|   | CHECKED    |            | DRAWING NO. |                        |        | REV. A |
|   | M.M.       | B6         | D2537       |                        | SHEET  | 1 OF 1 |
|   | DATE       |            | TILE        |                        |        | SCALE  |
|   | 96:05:15   |            | BUSHING     |                        |        | 1:1    |
|   | AI 02.0    | 8.30 OP A  | 0,316 WAS   | 0,313                  |        |        |







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WITHOUT NOTICE

MATERIAL: 304/316 SS 7/16 OD 0.063 WALL

OR 0.065 WALL

KE 81.09.07